

Work Order ID 77858

77858

Page 1

December-22-11 8:52:14 AM

Item ID: D3529-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 22/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3529	Rev A

110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D3529-1BLANK								

B 12-1-12

120	HAAS CNC VERTICAL MACHINING #1	0.00							
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA645 and Dwg D35293-Deburr								

PD 12/03/11

B 12-1-12

4 0

130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130									
QC	Memo	0.00							
Quality Control									

PD 12/03/11

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 12/03/12		4	0		
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00		PPS 77855		4	8	12-03-13	
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/3/13	

12/3/13

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Picklist Print

December-22-11 8:52:19 AM

Page 1

Work Order ID: 77858

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Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No			100	sf	683.6443	1.265	5.326316			
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MUHMWB10

B12-1-12

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

360

120035

360

MAT019

323.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

68.4443158

120035

(4)

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DART AEROSPACE LTD		Work Order:	77858
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.50	✓		VERN	RQ-02
B	0.07 x 45°	+/-0.030 x 0.5°	0.07	✓		VERN	GA-09
C	R0.25	+/-0.030	0.25	✓		R. G.	
D	0.250	+/-0.010	0.257	✓		Mic	118 120
E	0.625	+/-0.010	0.631	✓		Mic	118 120
F	0.950	+/-0.010	0.955	✓		Mic	118 120
G	1.63	+/-0.030	1.62	✓		VERN	GA-09
H	12.14	+/-0.030	12.14	✓			31006
I							
J	5.70	+/-0.030	5.70	✓		VERN	GA09
K	0.375	+/-0.010	0.385	✓		Mic	118 120
L	0.525	+/-0.010	0.535	✓		Mic	118 120
M	0.13 x 45°	+/-0.030 x 0.5°	0.130	✓		VERN	GA-09
N	R0.50	+/-0.030	0.500	✓		R. G.	
O	12.76	+/-0.030	12.75	✓			31006
P	3.38	+/-0.030	3.38	✓		VERN	GA-09 & 31006
Q	3.75	+/-0.030	3.75	✓		VERN	GA-09 & 31006
R	5.187	+/-0.010	5.185	✓			31006
S	5.25	+/-0.030	5.24	✓			31006
T	7.13	+/-0.030	7.12	✓			31006
U	Ø0.260	+0.006/-0.001	0.260	✓		Pin Gage	
V	0.30	+/-0.030	0.30	✓			GA-08
W	0.93	+/-0.030	0.93	✓		VERN	GA-09
X	1.30	+/-0.030	1.30	✓		VERN	GA-09

Measured by: PO	Audited by: BA	Prototype Approval:	N/A
Date: 12/03/11	Date: 12/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

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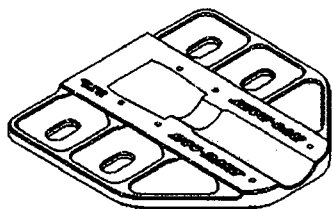
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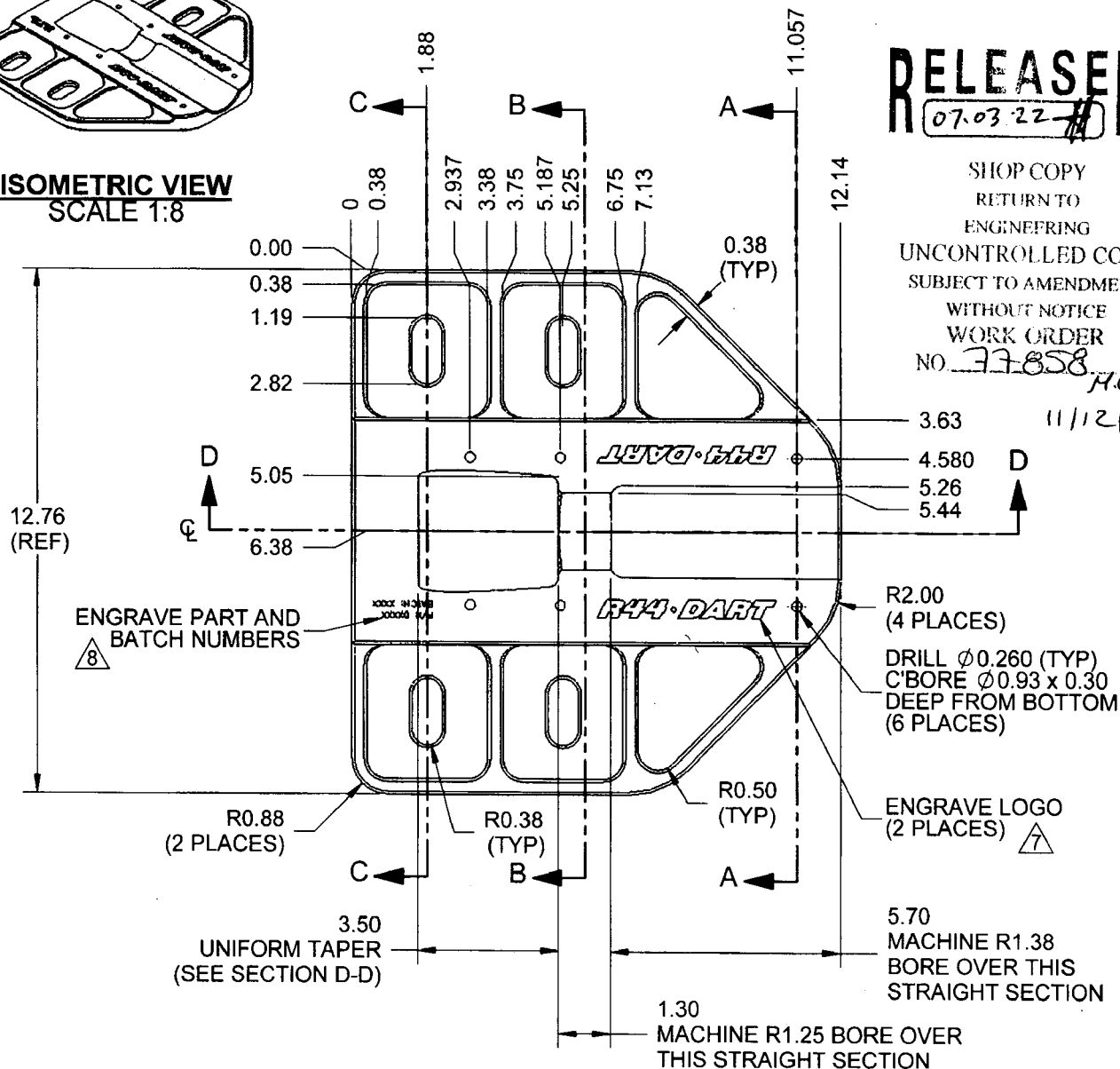
NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED A	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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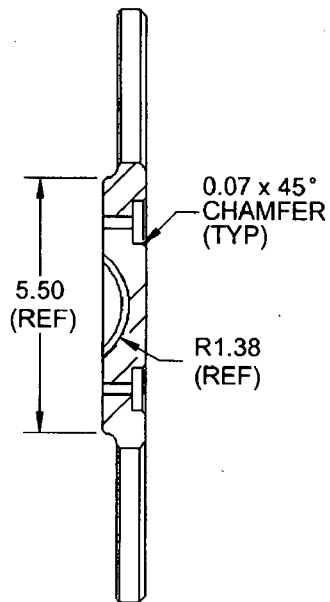
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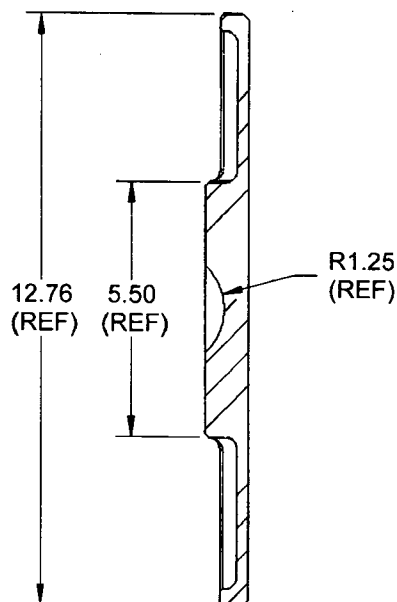


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529
DATE 07.01.04	TITLE R44 BEARPAW	REV. A SHEET 2 OF 2 SCALE 1:4

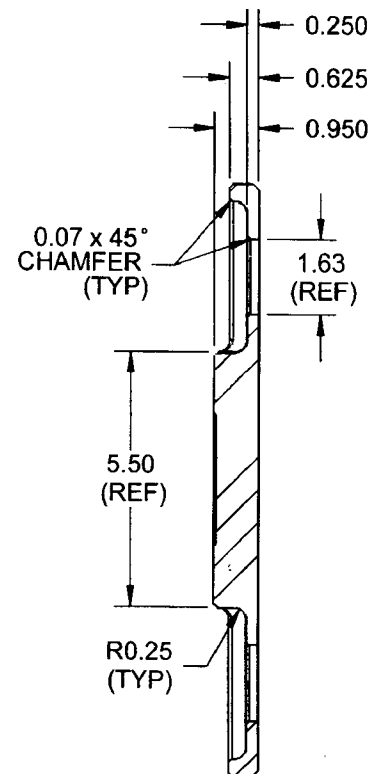
RELEASED
07.03.22



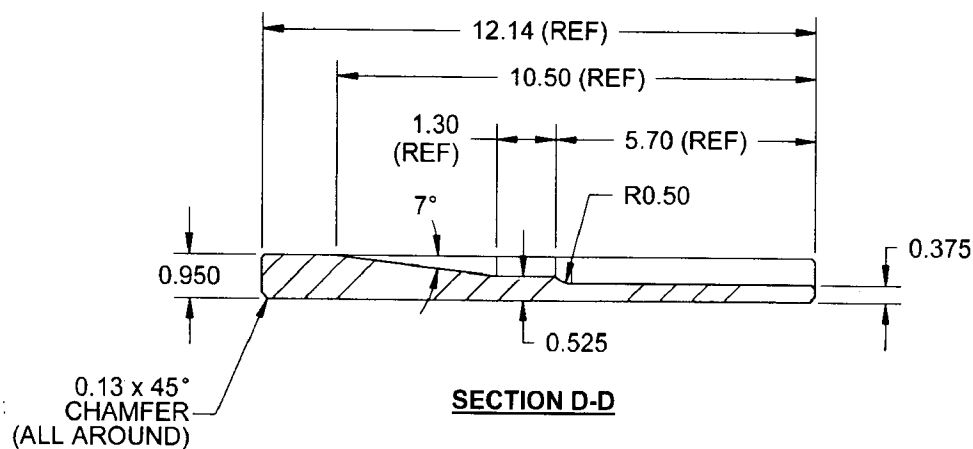
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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